

Date: Friday, 9/7/2007 10:14:17 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END PLATE
Job Number : 34454	
Estimate Number : 10547	
P.O. Number : <u>N/A</u>	Part Number : D30671
This Issue : 9/7/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3067 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34312	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 9/14/2007 Qty: 100 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est:03.01.21 Remove step 6 (Deburr) KJ	
Est Rev:B Now on Water jet 06-06-16 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0656 sf(s)/Unit Total : 6.5625 sf(s)  
 5052-H32 .063 Sheet  
 Material: 5052-H32 (QQ-A-250/8)  
 M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

Batch:

1104421 103783

SAD 07/09/09

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3067  
 Dwg Rev: A  
 Prog Rev: A

2-Deburr if necessary

SAH 07/09/11 100  
SAD 07/09/09 100

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/09 100

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAH 07/09/11 100

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Bend as per Dwg D3067

SAD 07/10/08 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3067-1 PAR #: N/A Fault Category: Prod / FAB ASS <sup>MAD & SMALL</sup> NCR: Yes No DQA: D Date: 07/10/10  
 QA: N/C Closed: ✗ Date: 07.10.12

NCR: <u>34454</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	2.0	Scrap 10 part, wrong material 2024 instead of 5052 PC. Mismatch error	<u>ASKUR</u>	Scrap destroy replace	<u>SAH</u> <u>07/09/10</u>	<u>SA</u> <u>07/09/10</u>	<u>ASKUR</u>	<u>ASGID</u>

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:14:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 34454

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

Er 07/10/09 (4100) (cont)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A 4

07-10-12 (100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

100 07/10/12

Job Completion



U 07/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

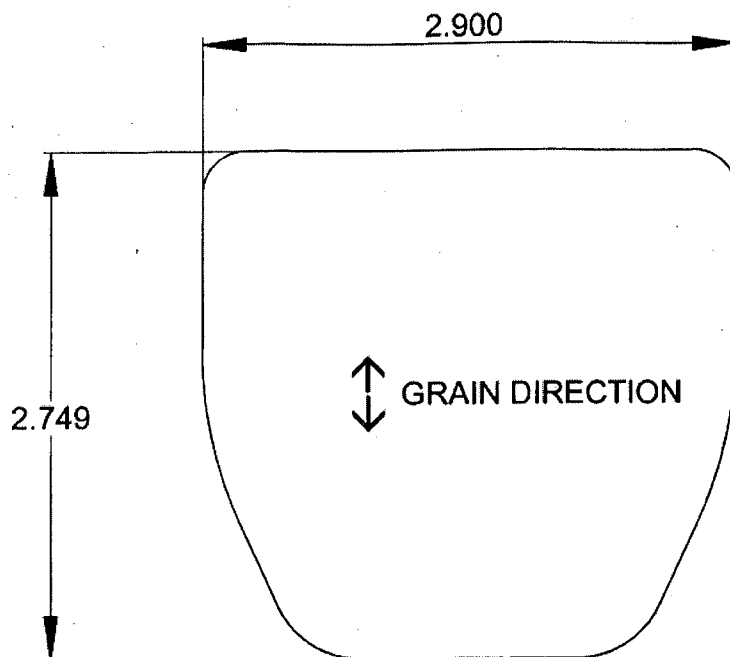
NOTE: Date & initial all entries



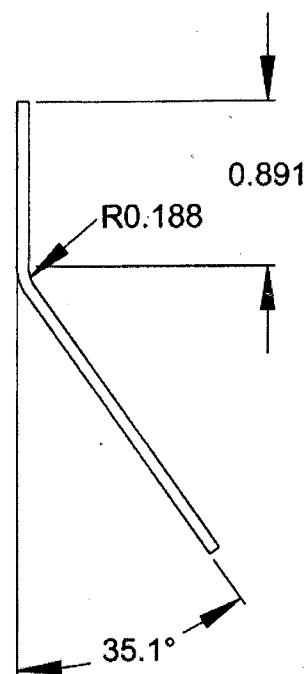


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3067</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>END PLATE</b>	SCALE 1:1
A	02.09.11	NEW ISSUE	

**RELEASED**  
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34454**

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)  
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)  
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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